

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029063**Date Inspected:** 30-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA observed the following welders working on the OBG at various locations:

ABF welder Wai Kit Lai #2953 was observed performing SMAW welding on the Deck Access Hole at 14E PP126. 5-E2-DAH. The welder was observed utilizing WPS ABF-D1.5-1040C-CU for SMAW. The welder was observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above. The work on the exterior of the plate was completed on this date.

FW Spencer welder Damien Llamas # 6645 was observed performing SMAW welding on pipe brackets to PS12 Channel at 4W PP27-W5 on the exterior of the OBG. The welder was observed utilizing WPS FWS-Fillets Murex for SMAW. The welder was observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above. RFI-003098R00 was referenced during observation. The work at this location was completed on this date.

ABF welder Mike Jimenez #4671 was observed performing FCAW seal welding on the 6mm x 75mm plates on the threaded holes of counterweight number 10 located at 1W PP8. The welder was observed utilizing WPS ABF-D1.5-F2200-2 for the Partial Penetration Joint. The welder was observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS

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noted above. RFI-002670R00 was referenced during this observation.

This QA Inspector performed Magnetic Particle (MT) testing on the West Retro-fit Stiffeners located at 13W PP119-WRS on the interior of the OBG. This QA Inspector performed MT testing utilizing the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.26.2.1. A total of 10% of the welds length was tested. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

This QA observed QC Inspector Steve Jensen and Salvador Merino performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. This QA also observed QC Inspector's John Hays performing various Non-Destructive Testing (NDT) on completed weld repairs as they became available for testing. Non-Destructive Testing methods utilized by the QC Inspectors were Visual Testing (VT), Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave (UTSW). QC Inspectors were observed performing inspection per applicable code and or contract criteria. Unless otherwise noted, all work observed on this date appeared to generally comply with the contract documents.

Summary of Conversations:

Conversations were relevant to work performed.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas 916-764-6027 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
